

Date: Tuesday, 11/11/2008 10:19:42 AM
 User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LATCH
Job Number	: 43304		
Estimate Number	: 12772		
P.O. Number	:	Part Number	: 41232 200 002 003
This Issue	: 11/11/2008 S.O. No. :	Drawing Number	: 41232-200-002 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 11 Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 39216	Material	:
Written By	: <u>JLM 11-11</u>	Due Date	: 18/11/2008 Qty: 12 Um: Each
Checked & Approved By	:		
Comment	: Est Rev:A New Issue 07-03-05 JLM Est Rev:B Now on Doosan Lathe 08-05-13 JLM Verified By:DD		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3R1875	2024 T3 ROUND BAR 1.875
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Comment: Qty.: 0.3675 f(s)/Unit Total : 4.4100 f(s)
 2024-T3 Round Bar 1.250"
 Batch: 110063

SA / 2p 08/12/10

2.0	DOOSAN LATHE	DOOSAN LATHE
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Comment: DOOSAN LATHE
 1-TURN AS PER FOLIO FA688 & DWG 41232-200-002,
 FOLIO REV: N/A
 DWG REV: A

2-DEBURR AS REQUIRED

3-Tap 1/4"28NF

4-GRIND RADIUS BY HAND

SA / 2p 08/12/10

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA / 2p 08/12/10

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

JLM 08/12/11

(15)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LATCH

Job Number: 43304

Part Number: 41232 200 002 003

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	OUTSIDE SERV.30	OUTSIDE SERVICES-MACH
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Comment: Sub-Contracting PURCHASING
Issue P/O: 7817
Black Anodize as per Dwg 41232-200-005
Ensure Certificate of Conformity is attached

08/12/12

(12)

Pc 8/12/12 (12)

6.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
Receive & Inspect For Transit Damage
Ensure certificate of conformity is attached

Pc 8/12/18 (12)

7.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

S 08/12/18 (X12)

8.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

Pc 8/12/19 (12)

9.0	QC21	FINAL INSPECTION/W/O RELEASE
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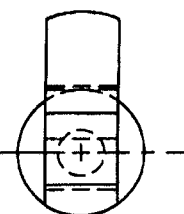
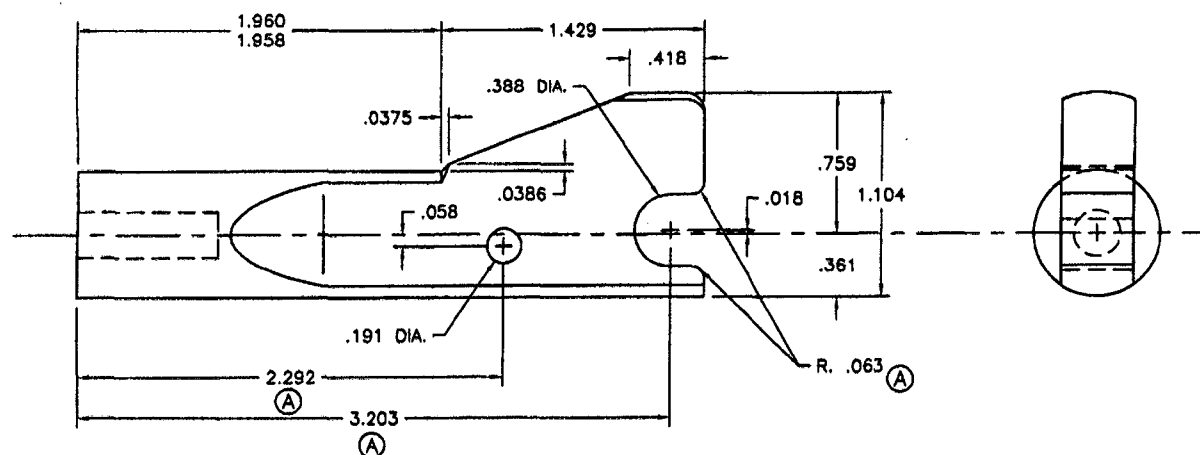
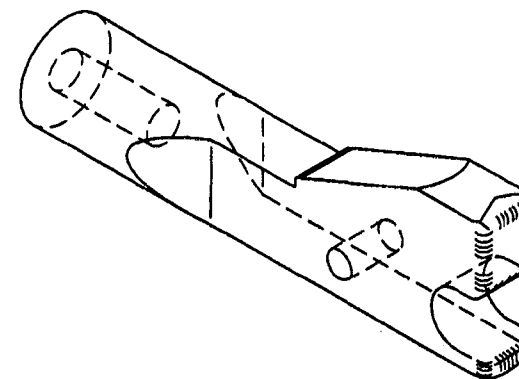
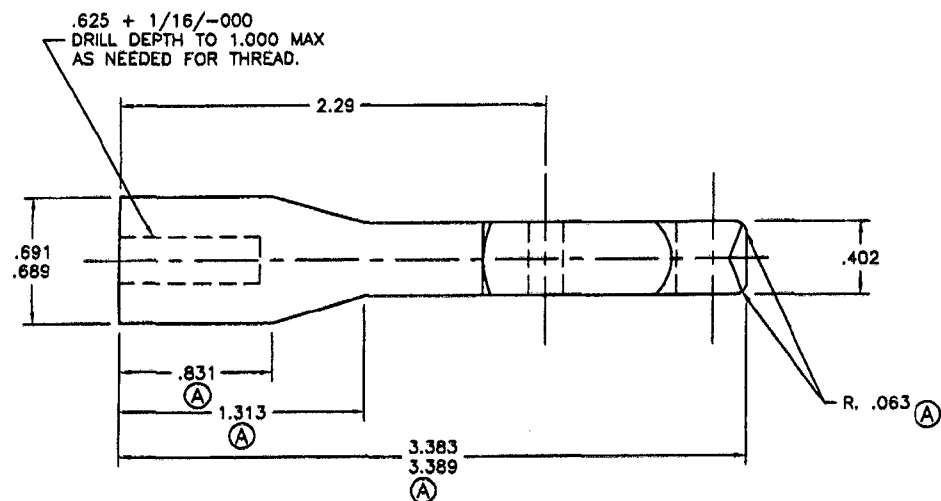
Comment: FINAL INSPECTION/W/O RELEASE

08/12/22

Job Completion



mf 08-12-19



w/o 43304

-003 LATCH

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Era Aviation, Inc.

TITLE
STEP ACTUATOR COMPONENTS

SIZE
C

DRW. NO.
41232-200-002
SHT 2 OF 3

REV
A

DART AEROSPACE LTD		Work Order: 43304
Description: Latch		Part Number: 41232-200-002-003
Inspection Dwg: 41232-200-002 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒
First Article
☐
Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.29	+/-0.030	2.294	/			
0.691/0.689	N/A	.690	/			
0.831	+/-0.010	.830	/			
1.313	+/-0.010	1.310	/			
3.383/3.389	N/A	3.386	/			
0.402	+/-0.010	.401	/			
R0.063	+/-0.010	R.063	/			
1.960/1.958	N/A	1.959	/			
1.429	+/-0.010	1.428	/			
0.345 0.375	+/-0.010	.037	/			
Ø0.388	+0.006/-0.001	Ø.388	/			
0.418	+/-0.010	.415	/			
0.386 0.386	+/-0.010	.038	/			
0.058	+/-0.010	.064	/			
Ø0.191	+0.005/-0.001	Ø.191	/			
2.292	+/-0.010	2.292	/			
3.203	+/-0.010	3.200	/			
0.018	+/-0.010	.018	/			
0.759	+/-0.010	.764	/			
1.104	+/-0.010	1.108	/			
0.361	+/-0.010	.386	/			
R0.063	+/-0.010	R.063	/			
1/4-28 x 1.000	N/A	1/4-28x1.0	/			

Measured by: SD
Date: 08/12/11

Audited by: gmf
Date: 08/12/11

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.09.12	New Issue	KJ/DD	DA

TNM ANODISATION et PEINTURE TNM INC.

21 chemin de l'Aviation, Pointe-Claire, QC H9R 4Z2

Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 certified

Certifié NADCAP certified

PACKING
SLIP

71086

17-Dec-2008

CLIENT / CUSTOMER:**DART AEROSPACE LTD.**

1270 ABERDEEN STREET

HAWKESBURY , ONTARIO

K6A 1K7

NO. DE COMMANDE:**PURCHASE ORDER/****7817//**

ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION	
1	12	12	41232 200 002 003 B43304	-
2	12	12	41232 200 002 003 B43305	-

**PICKED UP BY / RECU:** _____

En cas de perte ou de dommages dû a la la valeur intrinsèque de certaines responsabilité se limitera à deux fois la valeur du traitement des pieces perdues ou endommagées.

Due to the intrinsic value of some parts, we are only liable for loss or damage to twice the invoiced finishing costs.

TNM**ANODISATION et PEINTURE TNM INC.**

C. OF C

21 chemin de l'Aviation, Pointe Claire QC H9R 4Z2

Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 certified

approuvé NADCAP approved

71086

17-Dec-2008

CLIENT / CUSTOMER:**DART AEROSPACE LTD.**

1270 ABERDEEN STREET

HAWKESBURY , ONTARIO

K6A 1K7

**CERTIFICATE OF COMPLIANCE
CERTIFICAT DE CONFORMITE****NO. DE COMMANDE: 7817//
PURCHASE ORDER/**

1	12	12	41232 200 002 003 - B43304
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BLACK ANODIZE PER MIL-A-8625F TYPE II CLASS 2 ALL
OVER

2	12	12	41232 200 002 003 B43305
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BLACK ANODIZE PER MIL-A-8625F TYPE II CLASS 2 ALL
OVER

S
68/12/15

Nous certifions que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées.

Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.

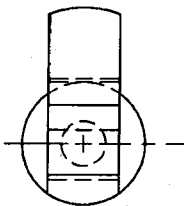
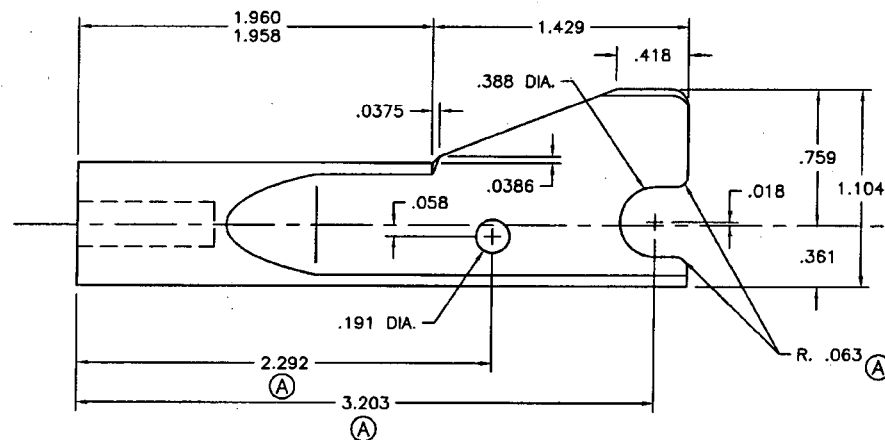
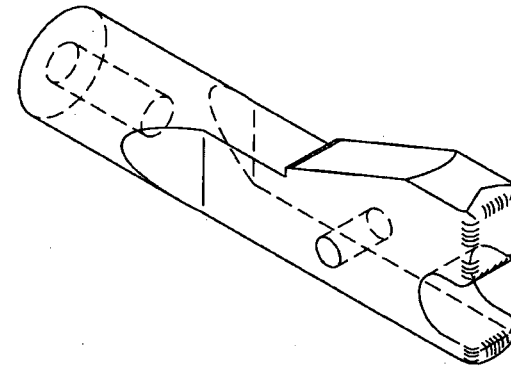
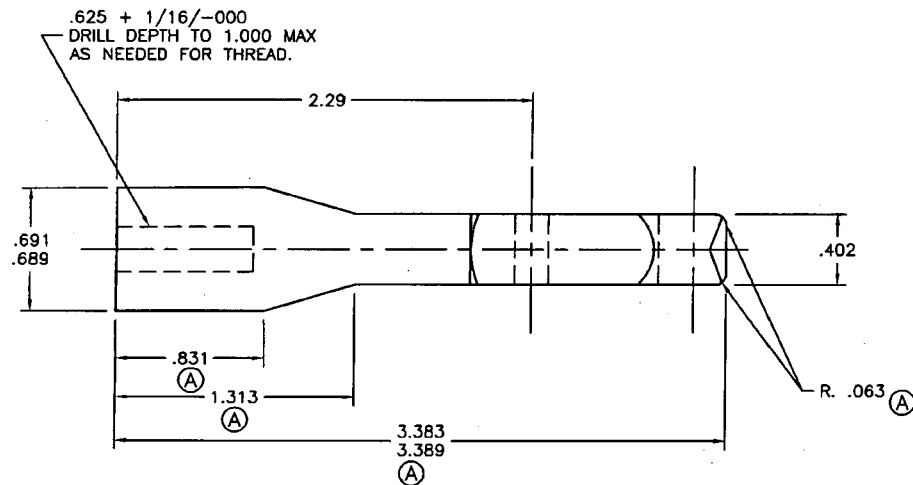
All parts are processed, tested, and inspected to the requirements of above specifications.

Travel cards have been filled and are available for viewing upon request.

NOTE: Painted Parts will be Fully Solvent Resistant after 7 (seven) Full Days of Air Curing at Ambient
Temperatures"

NOTE: Les pièces peintes seront complètement résistantes au solvant après 7 (sept) jours complets de séchage à l'air
ambiant.

Signature/Signed:**Directeur de la Qualité / Q.A. Manager**



REFERENCE ONLY

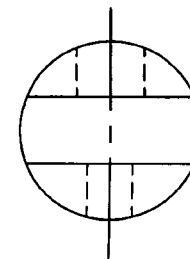
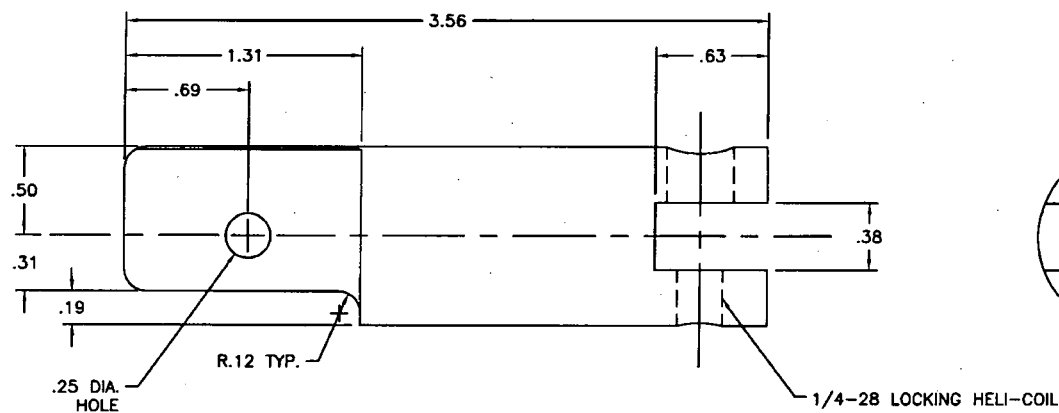
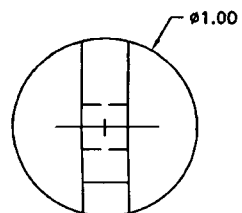
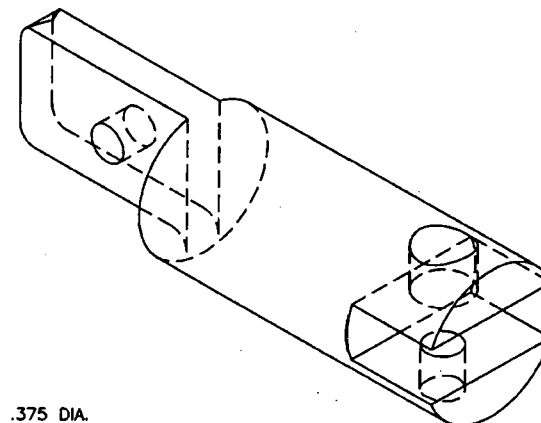
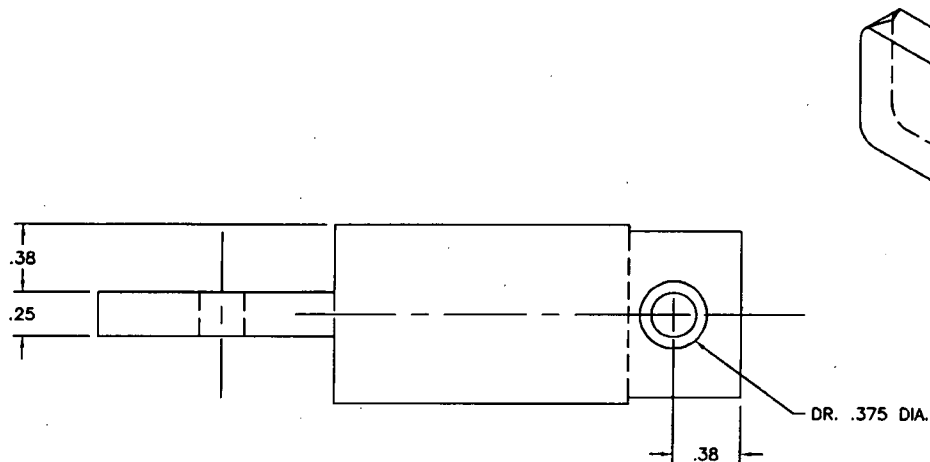
-003 LATCH

W/43304

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Era Aviation, Inc.

TITLE	SIZE	DRG. NO.	REV.
STEP ACTUATOR COMPONENTS	C	41232-200-002 SHT 2 OF 3	A



-005 PIVOT ARM

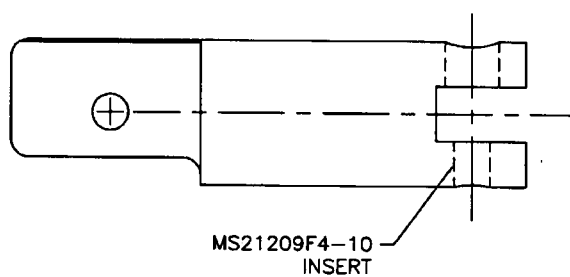
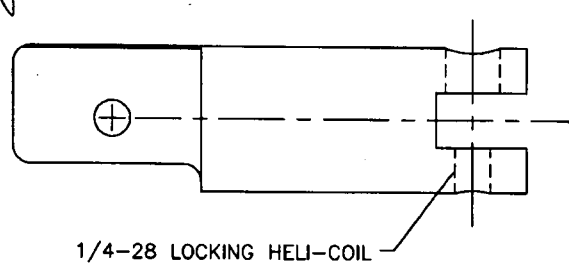
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W6 43304

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Era Aviation, Inc.

TITLE	SIZE	DWG. NO.	REV.
STEP ACTUATOR COMPONENTS	C	41232-200-002 SHT 3 OF 3	A

DATE 2/26/04	ENGINEERING ORDER	E.O. No. B-1	SHT. 1 OF 1						
BY D. NELSON	TITLE STEP ACTUATOR COMPONENTS	DWG. AFFECTED 41232-200-002							
APPROVED BY		SHEET AFFECTED SHT 1 & 3							
REASON FOR CHANGE: CHANGED DASH NO. OF INSERT ON L/M; CHANGED INSERT CALLOUT ON -005 PIVOT ARM.									
MINOR CHANGE - FAR 21.95									
<div style="display: flex; justify-content: space-around; align-items: center;"> <div style="text-align: center;"> <u>IS</u> <table border="1" style="margin: 5px;"> <tr> <td style="width: 30px; text-align: center;">1</td> <td style="width: 200px; text-align: center;">MS21209F4-10</td> <td style="width: 80px; text-align: center;">INSERT</td> </tr> </table> </div> <div style="writing-mode: vertical-rl; transform: rotate(180deg); font-weight: bold; font-size: 1.2em;">REFERENCE ONLY</div> </div> <div style="display: flex; justify-content: space-around; align-items: center;"> <div style="text-align: center;"> <u>WAS</u> <table border="1" style="margin: 5px;"> <tr> <td style="width: 30px; text-align: center;">1</td> <td style="width: 200px; text-align: center;">MS21209F4-15</td> <td style="width: 80px; text-align: center;">INSERT</td> </tr> </table> </div> </div>				1	MS21209F4-10	INSERT	1	MS21209F4-15	INSERT
1	MS21209F4-10	INSERT							
1	MS21209F4-15	INSERT							
<u>IS</u>  MS21209F4-10 INSERT		<div style="text-align: right; font-style: italic; font-size: 1.2em;">Wb 43304</div> <u>WAS</u>  1/4-28 LOCKING HELI-COIL							
<u>-005 PIVOT ARM</u>		<u>-005 PIVOT ARM</u>							
CHANGE REQUIRED:									
DATE:		BY:							
TRAVELER		YES							
INSTALLATION INSTRUCTIONS		NO							
MAINTENANCE INSTRUCTIONS									
ILLUSTRATED PARTS									
UNINCORPORATED DRAWING LIST									
MASTER DRAWING LIST									
COMPUTER DATA BASE									